



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RB T101992
Job Sheet 176828



Part No: RB T101992 *6 week* **Job Qty:** 2 ea

Part Name: Nut Scissors Sleeve & Wrench Assembly Sleeve



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 5/1/18

Job Tracking No:

Due Date: 5/28/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RB T101992 Rev. 1 IPP Rev. A 18.05.01 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	2 pcs		5/28/18	0.00	0.00	Purchasing		<i>18-06-07</i>
110	Packaging	2 pcs		5/28/18	0.00	0.00	Packaging2		<i>18-06-07</i>
120	QC	2 pcs		5/28/18	0.00	0.00	QC6		<i>18-06-08</i>
130	Packaging	2 pcs		5/28/18	0.00	0.00	Packaging3		<i>18-06-08</i>
140	QC21-FG	2 Ea		5/28/18	0.00	0.00	QC21		<i>18-06-08</i>

Part Op 100 - Issue P/O: *039773* MANUFACTURE RB T101992 AS PER DWG Supplier: AIRCRAFT HARDWARE ACCESS
Descriptions: -Certificate of conformity is required

X2 MAY 02 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RB T101992P	Nut Scissors Sleeve & Wrench Assembly Sleeve	2 (1 ea)	100-Purchasing	<i>507949</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RB T101992P	2	0	0

Part Specifications

Specifications could not be found.

Plex 5/2/18 8:00 AM dart.lavoie.chantal



Container No: S079120



Part: RB T101992

Job No: 176828

Serial No/Batch: S079120

Revision: 1

Inspector:

Exp Date: 06/07/2018

Instructions:

Dart Aerospace Ltd.

1270 Aberdeen Street

Hawkesbury, ON K64 1K7

CANADA

TEL.: 1 813 632-5200

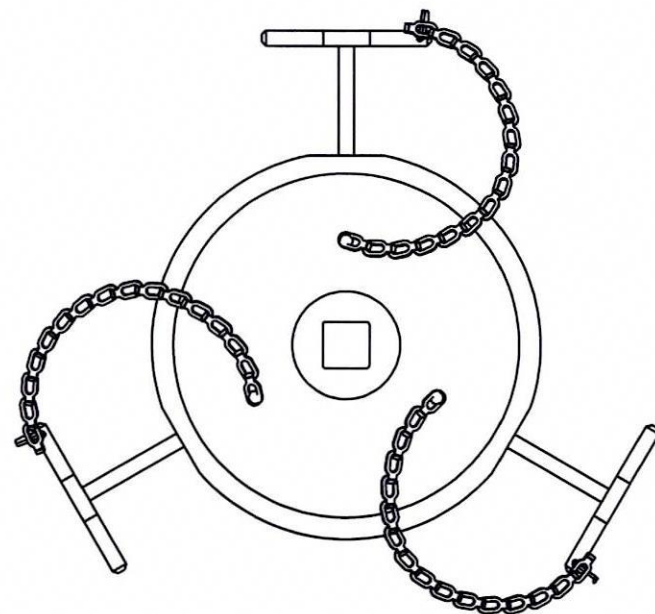
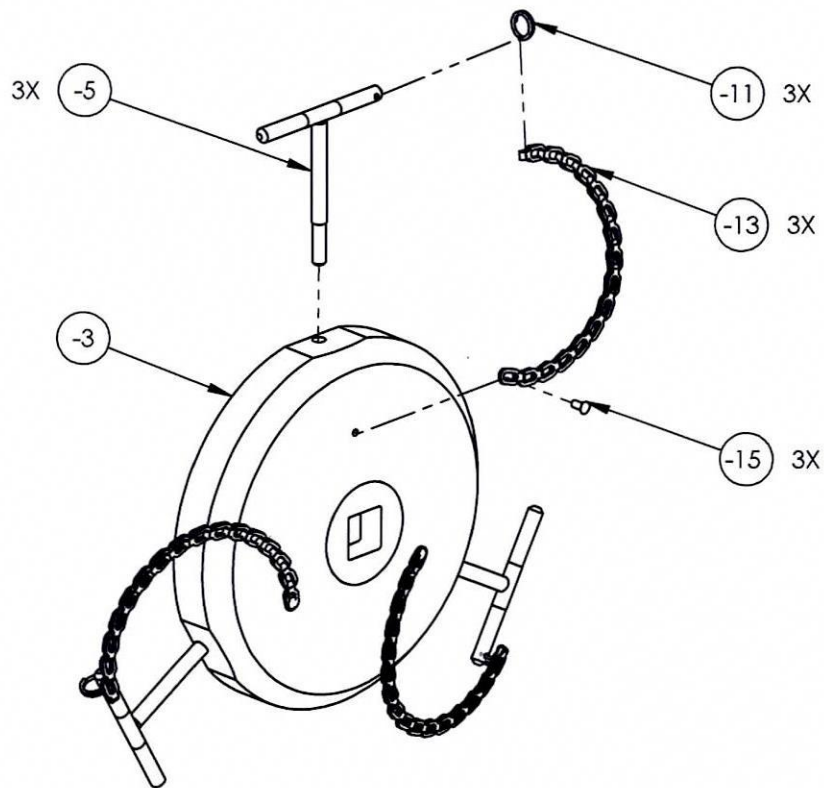
Email: sales@dartaero.com

www.dartaerospace.com

Date: 06/07/18

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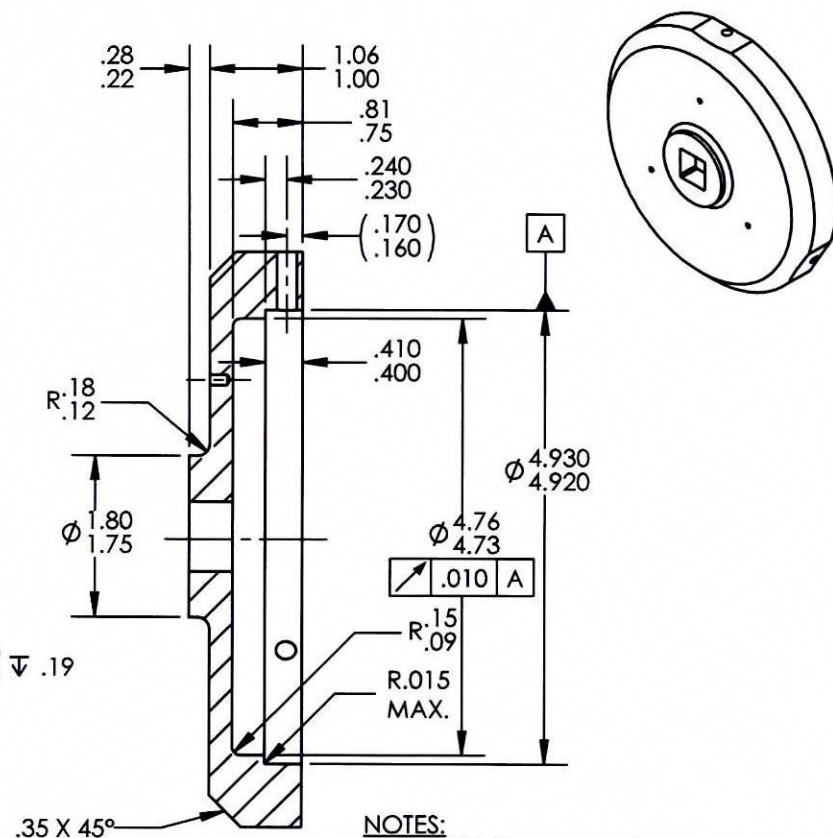
REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	REDRAWN FROM TATTERED DRAWINGS. -3 CH'D HOLE WAS Ø.090-.085 IS Ø.110-.105. -05 REMOVED -13 CHAIN FROM WELDMENT. -9 ADDED Ø.094 HOLE FOR -11. -13 CH'D ATTACHMENT METHOD WAS WELDED IS HOLE WITH RING -11. -15 WAS #2 DRIVE SCREW IS #4 DRIVE SCREW.	9/9/2013	CFS	GE



ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-3	1	WRENCH	4140	Ø6-1/2 X 1-1/2	2
	X		-5	3	PIN ASSY			3
	1		-7		PIN	O1	Ø1/4 X 2-3/4	4
	1		-9		HANDLE	O1	Ø1/4 X 3	5
		B/O	-11	3	SPLIT RING	STEEL	Ø1/2 MCMaster-CARR #86805T32	1
		B/O	-13	3	SASH CHAIN	BRASS	#1/10 X 7in. MCASTER-CARR #3608T22	1
		B/O	-15	3	#4 DRIVE SCREW	STEEL	1/4 MCMaster-CARR #90081A106	1
	ASSY -5							

RED BARN MACHINE	
TITLE	WRENCH ASSY - SLEEVE NUT
DWG NO.	RB T101992
MAT'L	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°
DRAWN BY:	SMITH
APPROVED	<i>D Weil</i>
HEAT TREAT	FINISH
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING
USED ON MODEL	214B, 214ST
SCALE	1:3
DATE	9/9/2013
SHEET 1 OF 5	

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	-3 CH'D HOLE WAS Ø.090-.085 IS Ø.110-.105.	9/9/2013	CF5	GE



SECTION A-A

NOTES:

1. ROUGH OUT THEN H/T AND FINAL MACHINING.
2. ORIENTATION TO SQUARE DRIVE NOT CRITICAL.

③
WRENCH

 RED BARN MACHINE

WRENCH ASSY - SLEEVE NUT

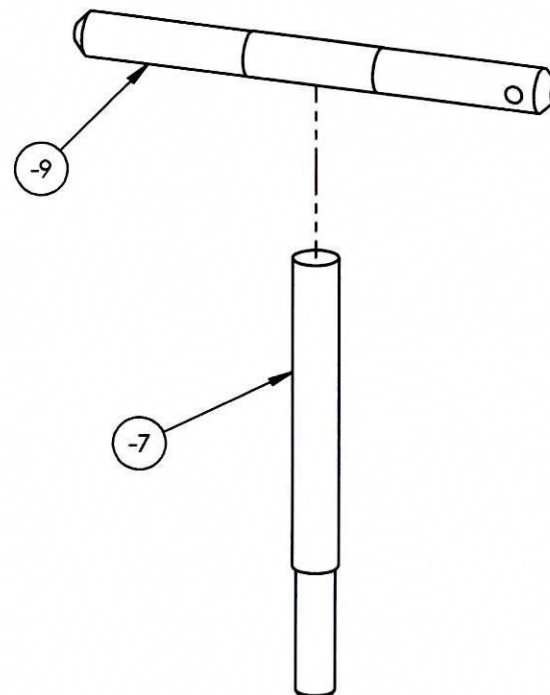
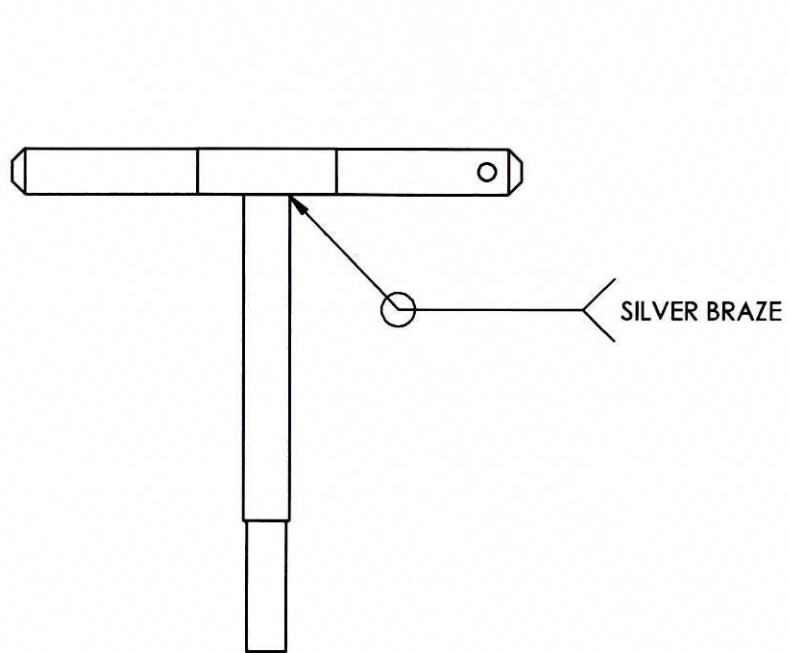
DWG NO. RB T101992-3

MAT'L 4140		DRAWN BY: SMITH	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		APPROVED <i>D. Meek</i>	
.XXX ± .005	FRACTIONS ± 1/32	HEAT TREAT	RC 27-32
.XX ± .01	ANGLES ± .5°	FINISH	CAD PLATE YELLOW
.X ± .01		SPEC	QQ-P-416F, TYPE II, CLASS II
1. BREAK ALL SHARP EDGES .015 x 45° OR .016"		USED ON MODEL	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING		214B 214ST	

SCALE	1:2	DATE	9/6/2013	SHEET 2 OF 5
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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	-05 REMOVED -13 CHAIN FROM WELDMENT.	9/9/2013	CFS	GE

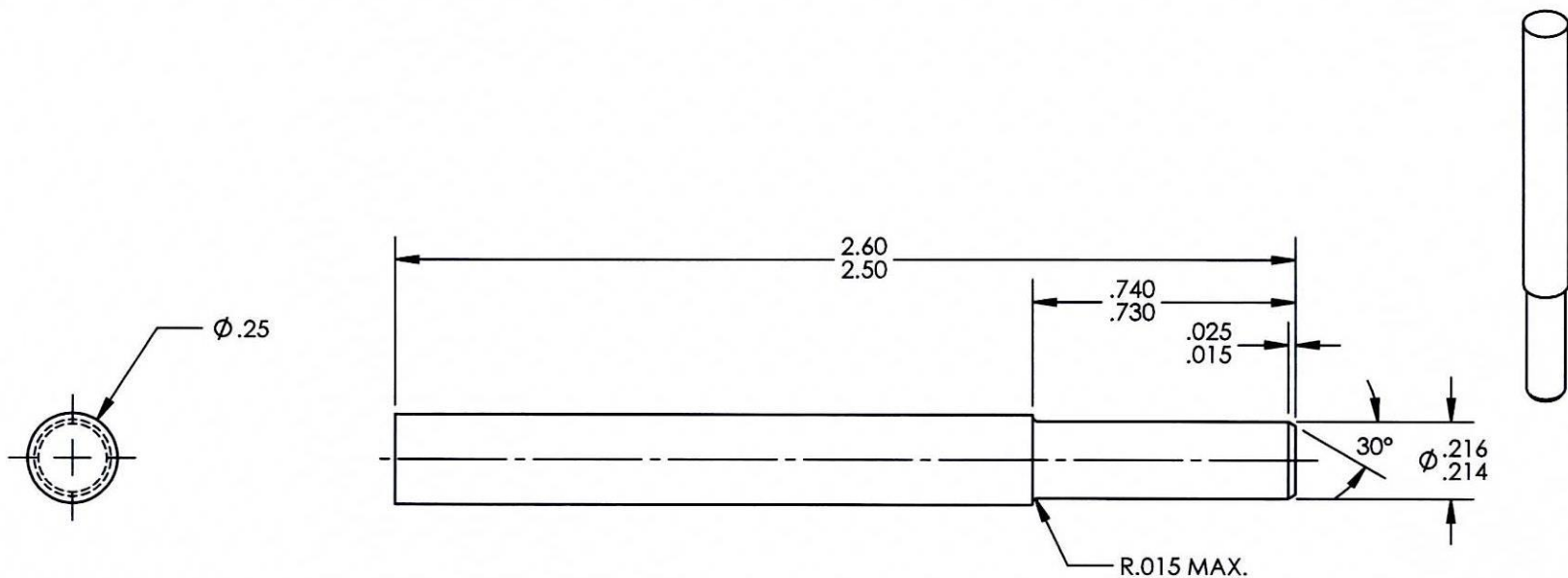


(5)
PIN ASSY

RED BARN MACHINE	
WRENCH ASSY - SLEEVE NUT	
DWG NO. RB T101992-5	REV 1
MAT'L	DRAWN BY: SMITH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D. Well</i>
.XXX ± .005 .XX ± .01 .X ± .1	HEAT TREAT FINISH CAD PLATE YELLOW
FRACTIONS ± 1/32 ANGLES ± 5°	SPEC QQ-P-416F, TYPE II, CLASS II
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL 214B, 214ST
SCALE 1:2	DATE 9/6/2013 SHEET 3 OF 5

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED

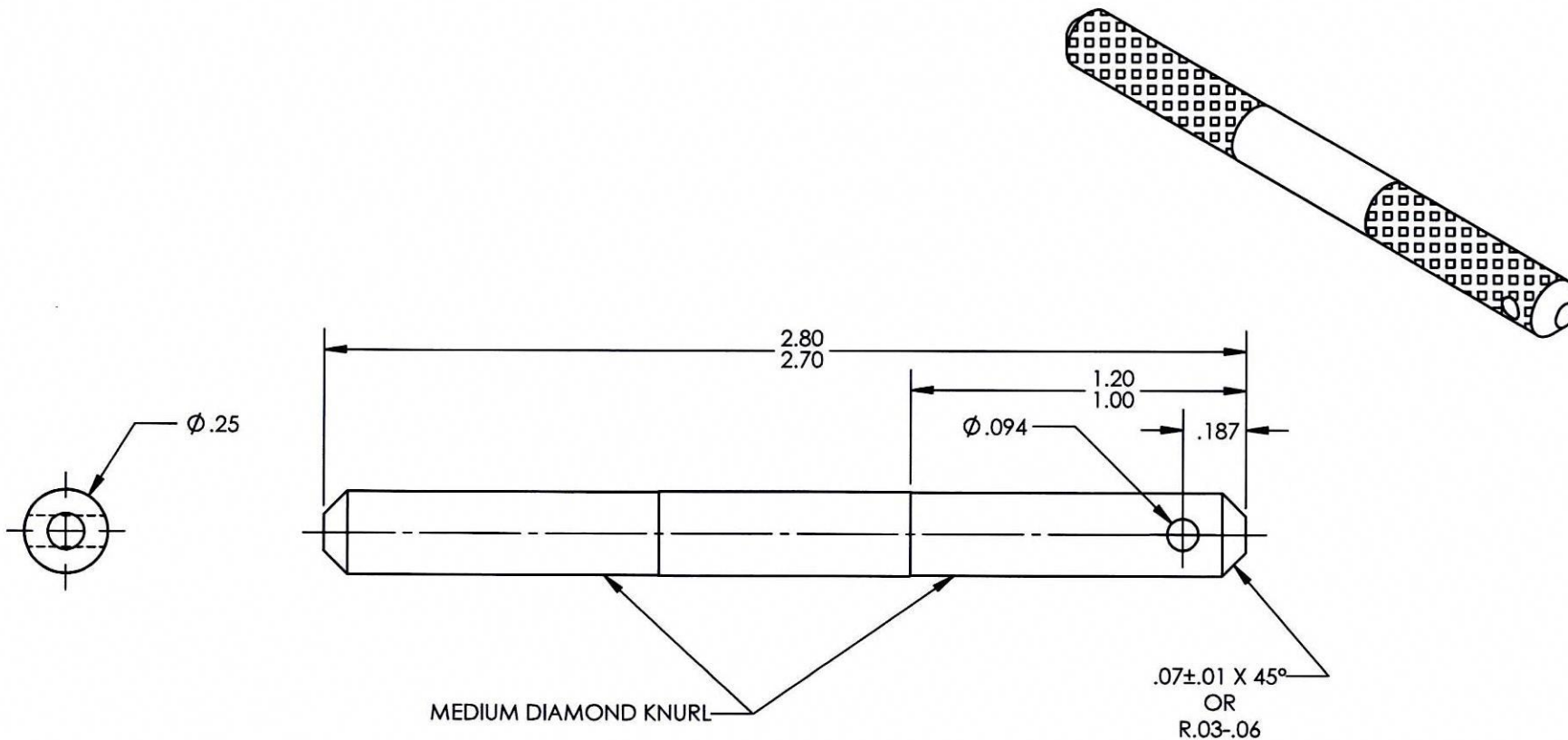


⑦
PIN

RED BARN MACHINE	
TITLE WRENCH ASSY - SLEEVE NUT	
DWG NO. RB T101992-7	REV ?
MAT'L O1	DRAWN BY: SMITH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D. Weil</i>
.XXX ± .005	HEAT RC 57-63
.XX ± .01	TREAT SEE -5 ASSY.
.X ± .1	FINISH
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL 214B, 214ST
SCALE 2:1	DATE 9/6/2013
SHEET 4 OF 5	

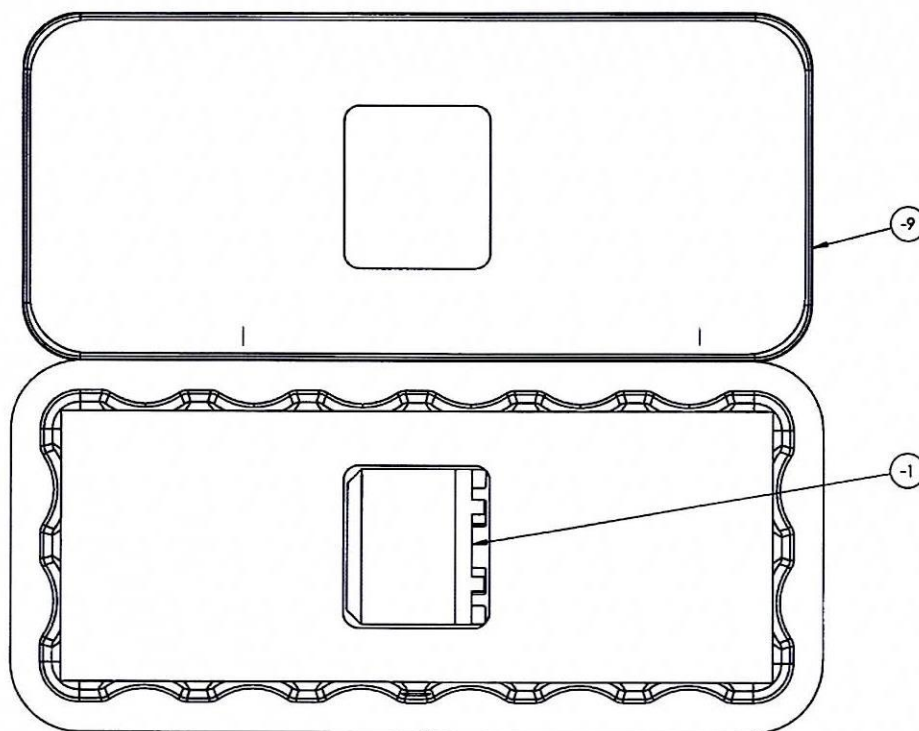
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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	-09 ADDED Ø.094 HOLE FOR -11.	9/9/2013	CFS	GE



RED BARN MACHINE	
TITLE WRENCH ASSY - SLEEVE NUT	
DWG NO. RB T101992-9	REV 1
MAT'L O1	DRAWN BY: SMITH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D. Weil</i>
.XXX ± .005	HEAT TREAT RC 57-63
.XX ± .01	FINISH SEE -5 ASSY.
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	214B, 214ST
SCALE 2:1	DATE 9/6/2013
SHEET 5 OF 5	

ITEM #	QTY	PART #	TITLE	PG	REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
-1	1	RBW6205G26551-3G-1	M/R SCISSOR LOCKNUT	2	1	RELEASED FOR PRODUCTION	-	4/13/2015	C	JAG
-9	1	RBW6205G26551-3G-9	PACKAGING ASSY	3	B	TEMPLATE UPDATED, ASSY -9 PACKAGING ADDED	17-796	17.12.20	VM	ML



RBW6205G26551-3G MAIN ROTOR SCISSOR LOCKNUT

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) SPEC: N/A
- 5) BREAK ALL SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A

DART AEROSPACE		Markham, Ontario, Canada	
TITLE			
MAIN ROTOR SCISSOR LOCKNUT			
PART NO.		REV	
RBW6205G26551-3G		B	
TOOL NO.			
RBW6205G26551-3G			
DESIGNED BY:		INITIALS AND DATE	
VM 17/12/20			
DRAWN BY:		TOLERANCES:	
VM 12/20/2017		XXX ±.008 FRACTIONS 2/16	
CHECKED BY:		XX ±.01 ANGLES 2.5°	
ML 12/21/2017		X ±.1 SURFACE	
MPG REVIEW BY:		POURNESS:	
DD 01/02/2018			
APPROVED BY:		SCALE: NTS	
ML 01/04/2018		SHEET 1 OF 1	
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO039773**

Supplier: AIH001-VU
Aircraft Hardware and Accessories
P.O. Box 14007
Ft Worth, TX 76617 USA

PO No: PO039773

PO Date: 5/2/18

Due Date: 5/8/18

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Lavoie, Chantal
clavoie@dartaero.com

Pynt Terms: Net 30

Freight Terms:

Special Comments:

E-MAILED
MAY 02 2018

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Items

Line Item	Part	Supplier Part No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	RB T102137- 111P		Lifting Tool As Per Dwg RB T102137- 111 Rev. A	Firmed	5/8/18	2 pcs	0 pcs	2 pcs	\$2,500.00/pcs	\$5,000.00
Line Item Note w/o 176839										
2	RB T101992P		Nut Scissors Sleeve & Wrench Assembly Sleeve	Firmed	6/5/18	2 Ea	0 Ea	2 Ea	\$530.00/Ea	\$1,060.00
Line Item Note W/O 176828										
									Grand Total:	\$6,060.00

Order Notes

Procurement Quality Clauses
A005 RIGHT OF ENTRY
A016 PERSONNEL QUALIFICATION
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A032 PUBLIC LAW 101-592 FASTENER QUALITY ACT
A033 STATEMENT OF CONFORMITY/TEST RECORDS FOR NAS, AN and MS FASTENERS
A040 NOTIFICATION OF QUALITY ESCAPE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENTS

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

CL
TS

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

AIRCRAFT HARDWARE & ACCES.
P.O. BOX 14007 FT. WORTH TX 76117
Phone: 817-680-3523 FAX- 817-416-5274
e-mail: sales@aircrafthardwareacces.com

Packing Slip

ATTN: Shipping Dept.

Date: 6/6/2018

TO: DART AEROSPACE

1270 ABERDEEN STREET

Hawkesbury ON K6A1K7

Packer # 60618

Cust. PO #: 39773

Qty	Tool #	REF#	Description
2	RBT101992		WRENCH ASSY

1306-02

ALL MATERIALS, PARTS OR COMPONENTS HAVE BEEN INSPECTED
AND COMPLY WITH THE PURCHASE ORDER REQUIREMENTS